

Split

ASAP

Work Order ID 58204-2



Thursday, April 29, 2010 10:36:36 AM

Page 1

Item ID: D3637-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/29/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: MK

Date: 10-4-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3637

Rev B

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 2-
Debur if necessary

HB 10-5-10



110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

HB 10-5-10

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

S. S. 10/10

canko
+20

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 58204

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3637

0.00

0.00

80 10/05/10

17

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

80 10/05/10

17

150



Small Fab

Small Fab

Small Fab

Memo

1- drill holes as per dwg using DT8979 2- c-sink holes as per dwg 3-deburr

0.00

0.00

7 m. 10/06/02

17x

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NOTE: Date & initial all entries

Work Order ID 58204

Thursday, April 29, 2010 10:36:36 AM



Page 3

Item ID: D3637-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/29/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

206662

(X17)

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

(X17) 10/06/07

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10/06/07 (17) Ø

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NOTE: Date & initial all entries

Work Order ID 58204

Thursday, April 29, 2010 10:36:36 AM



Page 4

Item ID: D3637-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/29/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 10.00



Customer:

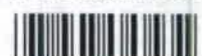
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: ST244A

0.00



Packaging

Memo

0.00

Packaging

(x17) JB 10/06/08.

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/09

M/10-6-08
(17)

| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 29, 2010 10:36:35 AM

Page 1

Work Order ID: 58204



Parent Item: D3637-3



Parent Item Name: Bracket

Start Date: 4/29/2010

Required Date: 5/14/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| M2024T3S.050 | | Purchased | No | | | 100 | sf | 43.3947 | 0.134 | 2.7 | | |



2024-T3 .050 sheet



B10-5-10

Location

Loc Qty

Loc Code

MAT22

43.3947

111381

32

112291

11

113189

0.3947

112291

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NOTE: Date & initial all entries

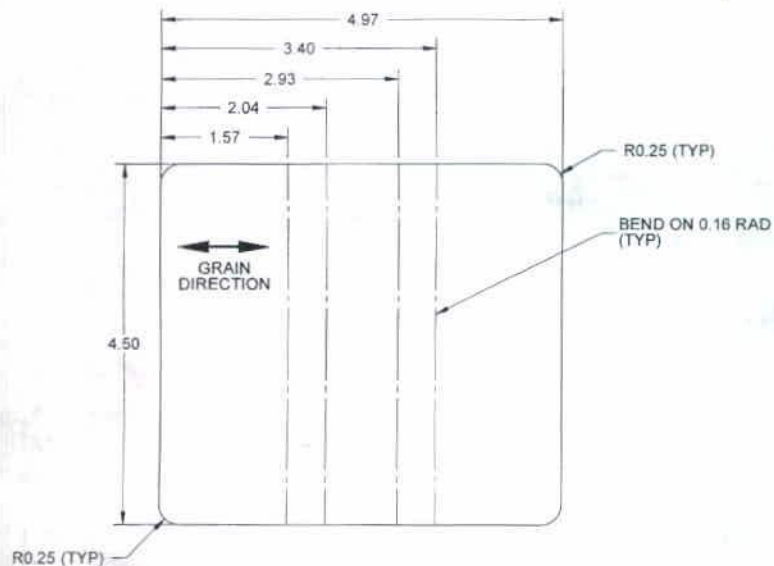
| W/O: | | WORK ORDER CHANGES | | | | | |
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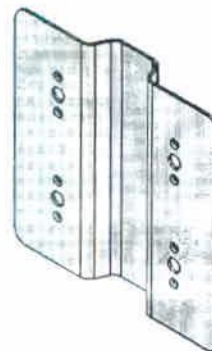
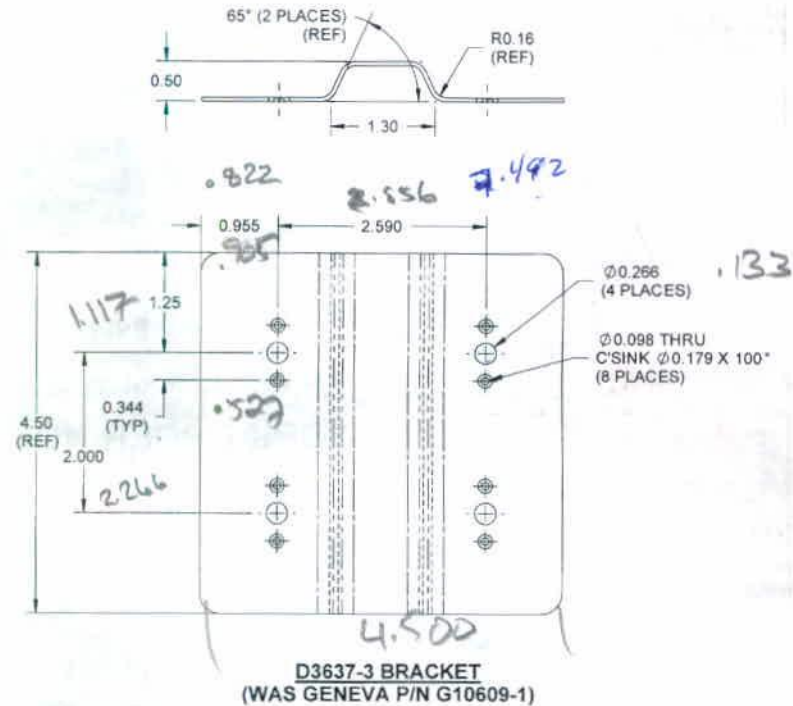
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NOTE: Date & initial all entries



D3637-3F FLAT PATTERN



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S 050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. B |
| MFG. APPR. | ED | D3637 | SHEET 3 OF 3 |
| APPROVED | MT | TITLE | SCALE |
| DE APPR. | MT | BRACKET | 2:3 |
| DATE | 07.12.18 | COPYRIGHT © 2007 BY DART AEROSPACE LTD | |
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